

Work Order ID 148413

Tuesday, June 28, 2016 10:11:36 AM

148413

Page 1

Item ID: D4061-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ski Cushion

Start Date: 6/22/2016 Start Qty: 36.00

36

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 36.00

36

Customer:

Reference:

Approvals:

Process Plan: U

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4061

C

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB292

FOLIO REV: AADWG REV: C

2-Deburr as required

0.72

360

DAS

14

9-59

16/08/07

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.06

360

DAS

14

9-59

16/08/07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval					
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY											
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS
120						36	0		45
QC	Memo	0.12							9-89
Quality Control									2016-8-7
130	Identify as per dwg & Stock Location: <u>ST344</u>	0.00							
130						36	PC		AUG 10 2016
Packaging	Memo	0.06							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.60							
Quality Control									

AUG 08 2016 RAH 16.08.10

SA

DQA: _____ Date: _____

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Picklist Print

Page 1

Tuesday, June 28, 2016 10:11:36 AM

Work Order ID: 148413

148413

Parent Item: D4061-1

D4061-1

Parent Item Name: Ski Cushion

Start Date: 6/22/2016

Required Date: 6/27/2016

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP REV:A NEW ISSUE JLM 10-02-18 VERIFIED BY:EC IPP
REV:B 11.01.10 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	14.0440	0.4125	15.63158			

D4287-3

Uhmw U-Channel

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST479a	14.044	
142561	7.75	
144484	6.294	

145242 → 16'
147816 → .967

16/08/06
DAS
14
9-50

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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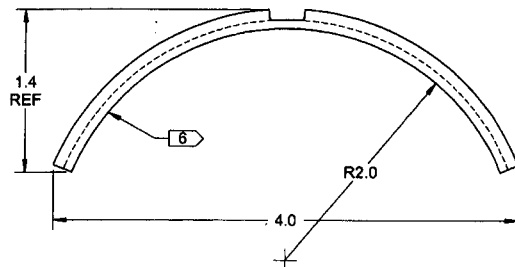
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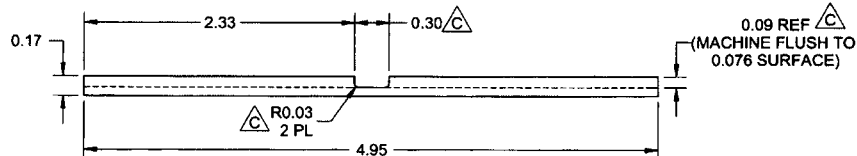
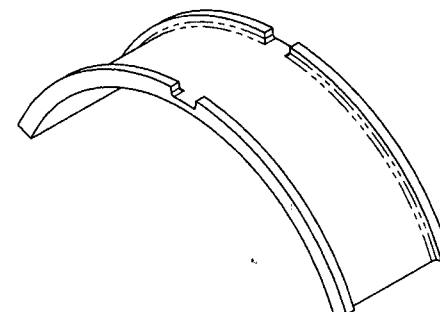
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8 7 6 5 4 3 2 1

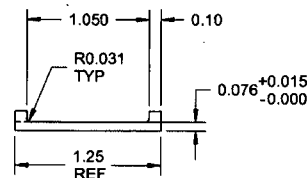


D4061-1 412 SKI CUSHION
(MAKE FROM D4061-1F)

WLO 148413



D4061-1F FLAT MACHINED STATE 1



RELEASED
2015-06-03
EN 15-574

- NOTES:**
- 1) MATERIAL: MAKE FROM D4287-3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4061-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

C	ADD 0.30 NOTCH, 2 PL, REF DIMS FOR D4060-1, REASON: PAR 14-368, 14-331, NCR 14-3521	VS	15.05.14
B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH ADEQUATE RADIUS. REF: PART10-29.	MB	10.12.07
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. D4061 REV. C	
MFG. APPR.	DD	SHEET 1 OF 1	
APPROVED	HS	TITLE 412 SKI CUSHION SCALE NTS	
DE APPR.	DS		
DATE	15.05.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1

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